

Right hand

Work Order ID 67876

Monday, April 04, 2011 8:34:27 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 1.00

Customer:

Reference: CUSTOM

Approvals: Process Plan: 11

Date: 11-04-11 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580-041

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041

CHG003

CHG002 5/16/04

11-05-11

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

DP

11-4-19

67876

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Start Date: 4/4/2011 Start Qty: 1.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for swaging as per QSI 002								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

4/04/25

1

11/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

M116577

BB 11/04/26

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start
expansion and finish with 1/2 x 18G to achieve dwg dimention.A/R
M116577

BE 11/04/26

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. DeburBB
BE

11/04/27

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Quality Control

Memo

0.00

8 11/04/26

FD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/04/29

(IX)

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

m-l 11/04/29 (IX)

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:1:20
320°F
1:50

m-l 11/04/29 (IX)

M 116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

8 w/04/29



QC

Memo

0.00



Quality Control

W/O:		WORK ORDER CHANGES					
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Monday, April 04, 2011 8:34:27 AM



Page 6

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ Sikaflex-291 ☐

Sikaflex expire date:

116918
12/15/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ Sikaflex-291 ☐

Sikaflex expire date:

116918
12/15/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

117315



m-l 11/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 67876

Monday, April 04, 2011 8:34:27 AM



Page 7

Item ID: D205-634-041

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

*Subtotal**70**Pto ->*

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

Call 11/5/4

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/5/4**mf**11-05-04*

W/O: 67876		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty.	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/05/04	#220	Holes were drilled on this ship tube for electric Step. work done on Attached custom work order. All work Done Per ZIN D412-673, D412-673-011 B34704 H412003	JA	11/05/03		11.05.04 PS1012	11/05/04

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, April 04, 2011 8:34:34 AM

Page 1

Work Order ID: 67876

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 4/4/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev: O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 Spacer	D2579	Manufactured	No			140	Each	303.0000	20	20			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG002</div> <div>303</div> <div></div> </div>													
<div> <div>66929</div> <div>106</div> <div></div> </div>													
<div> <div>67129</div> <div>196</div> <div></div> </div>													
<div> <div>67308</div> <div>1</div> <div></div> </div>													
D2580-1 205 Skidtube bent detail		Manufactured	No			110	Each	2.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>2</div> <div></div> </div>													
<div> <div>67646</div> <div>2</div> <div></div> </div>													
D2576-3 Step (maching detail)		Manufactured	No			140	Each	16.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>16</div> <div></div> </div>													
<div> <div>52215</div> <div>16</div> <div></div> </div>													

D2579

B

62400

BE 4/4/20

20

D

11-4-19

BE 4/4/20

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Monday, April 04, 2011 8:34:34 AM

Work Order ID: 67876

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 4/4/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2855
Cap
Manufactured No

200 Each

71.0000

1

1



m-l 11/04/30

Location

Loc Qty

Loc Code

FP007

71

53791 ✓

34

65519

2

65569

35

1X

AN3-5A
Bolt
Purchased No

200 Each

515.0000

2

2



m-l 11/04/30

Location

Loc Qty

Loc Code

ST350

515

115371 ✓

500

116632

15

2X

AN960JD10L
Washer
ALS7-1032-130
Insert
Purchased No

200 Each

0.0000

2

2



2X m-l 11/04/30

Location

Loc Qty

Loc Code

ST282

417

116800

417

200 Each

417.0000

50

50



m-l 11/04/30

50X

AN3C4A
BOLT
Purchased No

200 Each

1,408.000

50

50



m-l 11/04/30

50X

Location

Loc Qty

Loc Code

ST350

1408

116924 ✓

408

117094

1000

Monday, April 04, 2011 8:34:35 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Monday, April 04, 2011 8:34:35 AM

Work Order ID: 67876

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 4/4/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No 200 Each 0.0000 50 50



washer

D3566-13



Gasket

Manufactured No

M117291



SD m-k 11/04/30

1 1



m-k 11/04/30

Location

Loc Qty

Loc Code

FP014

22

66550 ✓

22

D3566-5

Manufactured No

200

Each

28.0000

1



Gasket



m-k 11/04/30

Location

Loc Qty

Loc Code

FP015

28

66552 ✓

6

67589 ✓

22

D3566-1

Manufactured No

200

Each

22.0000

2



Gasket



m-k 11/04/30

2X

Location

Loc Qty

Loc Code

FP015

22

67579

22

D3564-11

Manufactured No

200

Each

4.0000

1



Wearshoe



m-k 11/04/30

1X

Location

Loc Qty

Loc Code

FP019

4

66154

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Work Order ID: 67876

Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 4/4/2011



Required Date: 4/20/2011



Start Qty: 1.00

Required Qty: 1.00



D3564-13 Manufactured No 200 Each 39.0000 1 1

 Wearshoe  m-l 11/04/30

Location	Loc Qty	Loc Code
FP017	39	
66136	16	
66549	7	
66805	16	

D3564-9 Manufactured No 200 Each 0.0000 1 1

 Wearshoe 67590  m-l 11/04/30

D3564-5 Manufactured No 200 Each 13.0000 1 1

 Wearshoe  m-l 11/04/30

Location	Loc Qty	Loc Code
FG	2	
34806	2	
FP019	11	
66551	11	

D2594-3 Manufactured No 200 Each 1,384.000 16 16

 O-Ring, 205 Skidtube  m-l 11/04/30

Location	Loc Qty	Loc Code
FP-A	1384	
65518	384	
66952	1000	

Monday, April 04, 2011 8:34:35 AM

Shop Packet Print

Page 4

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Parent Item Name: Replacement Skidtube

Start Date: 4/4/2011

Required Date: 4/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

419.0000

16

16



Plug, 205 Skidtube



mk 11/04/30

Location

Loc Qty

Loc Code

FP-A

419

42807

28

66122

164

66932

220

67441

7

16x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]*

DEO ATTACHED

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67876

[Signature]

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

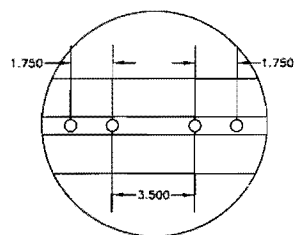
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

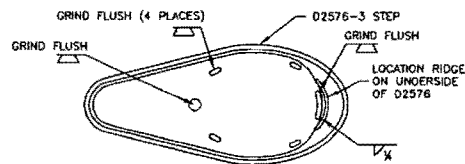
NOTE: Date & initial all entries

u/b 67.875

DETAIL E
SCALE 5:24



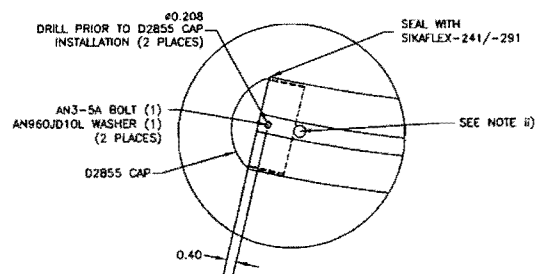
DETAIL F
SCALE 5:24



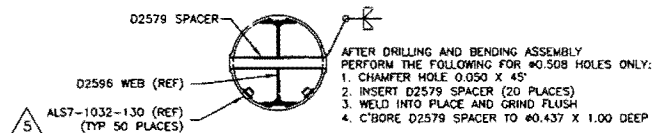
RELEASED
07.06.28

DEO ATTACHED

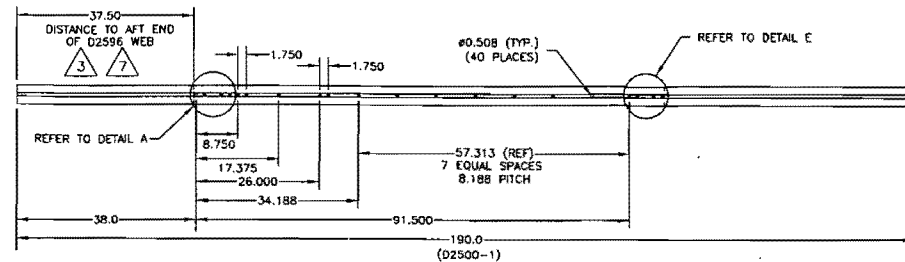
DETAIL G
SCALE 5:24



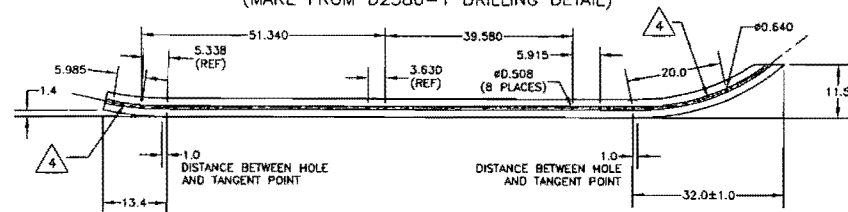
SECTION H-H
SCALE 5:24



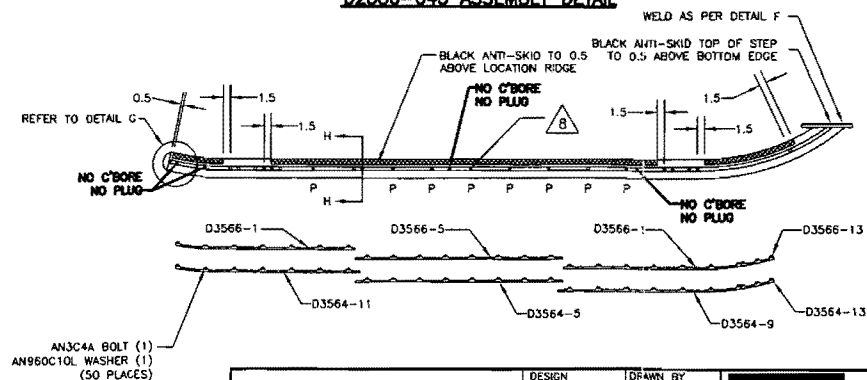
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

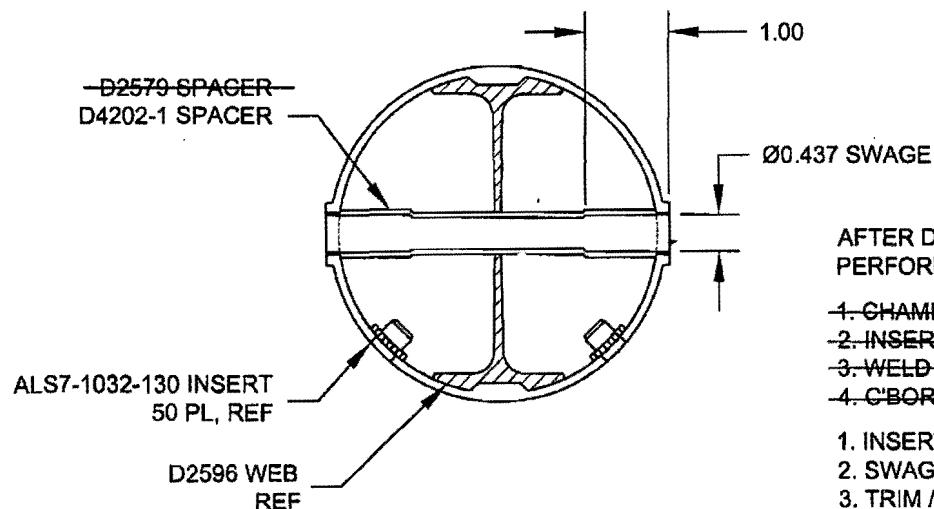
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April 18, 2011 11:36 AM
To: Linda Lacelle; Mike Petsche
Cc: Bill Beckett; 'Chris Provencal'; 'Eric Charbonneau'
Subject: Re: Alum. Solution Anneal - swaging

Makes sense to me ... We don't want to get caught short ... Make sure that if we do this, they are identified with the old CHG number.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Linda Lacelle" <llacelle@dartaero.com>
Date: Mon, 18 Apr 2011 11:21:10 -0400
To: 'Mike Petsche' <mpetsche@dartaero.com>; <dshepherd@dartaero.com>
Cc: 'Bill Beckett' <bbeckett@dartaero.com>; 'Chris Provencal' <cprovencal@dartaero.com>; 'Eric Charbonneau' <echarbonneau@dartaero.com>
Subject: RE: Alum. Solution Anneal - swaging

I am ready to weld some ^{up}, I don't want to get into trouble with L/T's on these, any objections??
LL

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: April 18, 2011 10:42 AM
To: 'Linda Lacelle'; dshepherd@dartaero.com
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Eric Charbonneau'
Subject: RE: Alum. Solution Anneal - swaging

Well I'm not sure what to say.

CHG 007

D2579

It is my understanding that the swaging will still make sense even with the extra hoops we need to jump through.

If there is still uncertainty on the delivery of the material, we CAN still weld them if we need to.

And while this might be less than "world class", couldn't we take some of our tubing that we have in stock and zap it with the welder to knock down the temper a little? Ground clamp on one end, torch on the other.....BZZZZZZT.

(I'm only sort of joking...because I bet it would work)

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April 18, 2011 9:44 AM
To: dshepherd@dartaero.com; 'Mike Petsche'
Cc: Bill Beckett; Chris Provencal; Eric Charbonneau
Subject: RE: Alum. Solution Anneal - swaging
Importance: High

So any thoughts about going fwd for now with 205's? We are down to 6, and I don't want to run out as we have orders for these for early May.

LL

From: Linda Lacelle [mailto:llacelle@dartaero.com]

Sent: April 12, 2011 8:11 AM

To: dshepherd@dartaero.com; 'Mike Petsche' (mpetsche@dartaero.com)

Cc: Bill Beckett (bbeckett@dartaero.com); Chris Provencal (cprovencal@dartaero.com); Eric Charbonneau (echarbonneau@dartaero.com)

Subject: FW: Alum. Solution Anneal - swaging

So if we send them 400 pds of the 6061T6 tube, they can temper it to T4 for a cost of 1850.00...

LL

From: John Spencer [mailto:johns@metcor.biz]

Sent: April 12, 2011 8:04 AM

To: llacelle@dartaero.com

Subject: Alum. Solution Anneal

Linda,

Metcor could process the tubes within a few days after receiving.

Price for the lot is \$1850 including conductivity test.

Would prefer 8 inch cut to length, if not we could manage 4 " lengths .

Please let me know and contact me on my cell.

Regards,

John Spencer

Metcor Inc.

Metcor Certified

johns@metcor.biz

514-386-1620

NO. 249

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 67531
Part number: D205 634 041
Description: 205
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

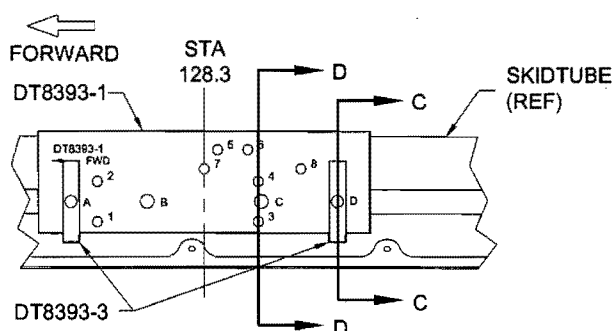
Qualifier Pat Farnsworth Date of Test Coupon 11.04.25

Welder Barclay Elliott Date of Test Coupon 11.04.25

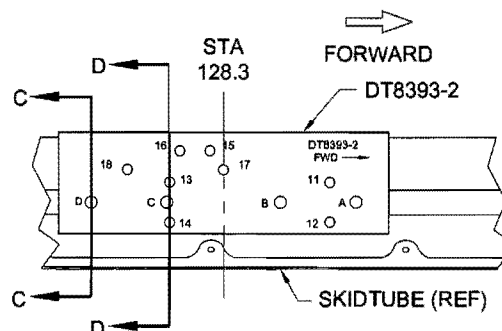
The above named individual is qualified in accordance with AWS D17.1.2001 to weld

DART AEROSPACE LTD	Work Order :	B 67876
D205-634-041	Description:	Disassemble
		Assemble
R/H	Approval :	
		Page 1 of 1

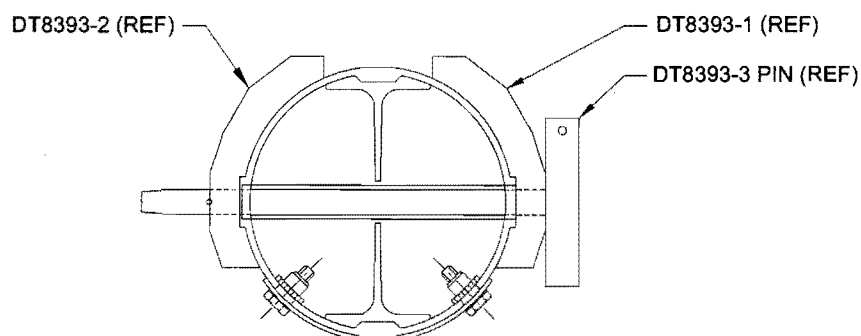
Step	Location	Procedure	By	Date												
1	PK	Remove from Stock <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D205-634-041</td> <td>skid tube</td> <td>B</td> </tr> <tr> <td></td> <td>D412-673-011</td> <td>Electric Step Adapter</td> <td>B34704</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D205-634-041	skid tube	B		D412-673-011	Electric Step Adapter	B34704		11/05/02
Qty	Part Number	Description	Batch													
1	D205-634-041	skid tube	B													
	D412-673-011	Electric Step Adapter	B34704													
2	PK	Return to Stock <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D205-634-041</td> <td></td> <td>67876</td> </tr> <tr> <td>1</td> <td>D412-673-011</td> <td></td> <td>34704</td> </tr> </tbody> </table> Assemble with Electric Step Adapter per IIN 412-673 For SO 10214 For Air Methods	Qty	Part Number	Description	Batch	1	D205-634-041		67876	1	D412-673-011		34704		11/05/03
Qty	Part Number	Description	Batch													
1	D205-634-041		67876													
1	D412-673-011		34704													
3		Drilled Holes IAW IIN 412-673 AND USED Drill jigs DT8393-1 and DT8393-2		11/05/03												
4		PCS Add Parts to kit D4398-1 2474 B69170 QC4 inspect kit Kit is at CHGWS due to DS29556 ECN 11-56		11/05/04												
5.0																
6.0																
	DC	Close W/O Inspect Level 21		11/5/4												



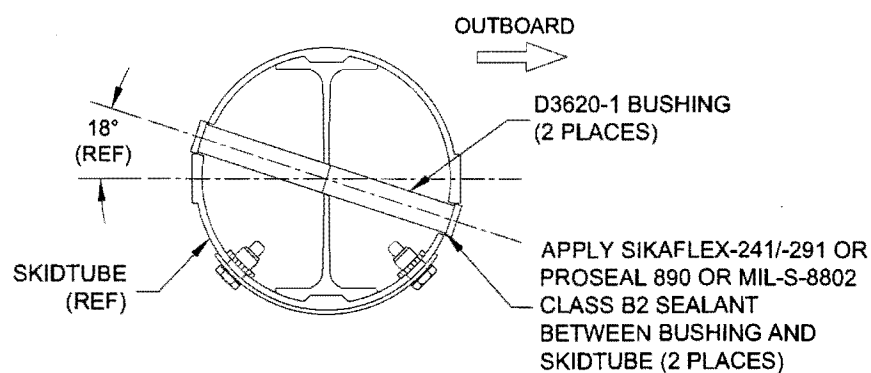
View A-A – Typical DT8393-1 Position
(See Figure 4.1; Tool Alignment at STA 128.3
Shown, Other STA Positions are Similar)



View B-B – Typical DT8393-2 Position
(See Figure 4.1; Tool Alignment at STA 128.3
Shown, Other STA Positions are Similar)

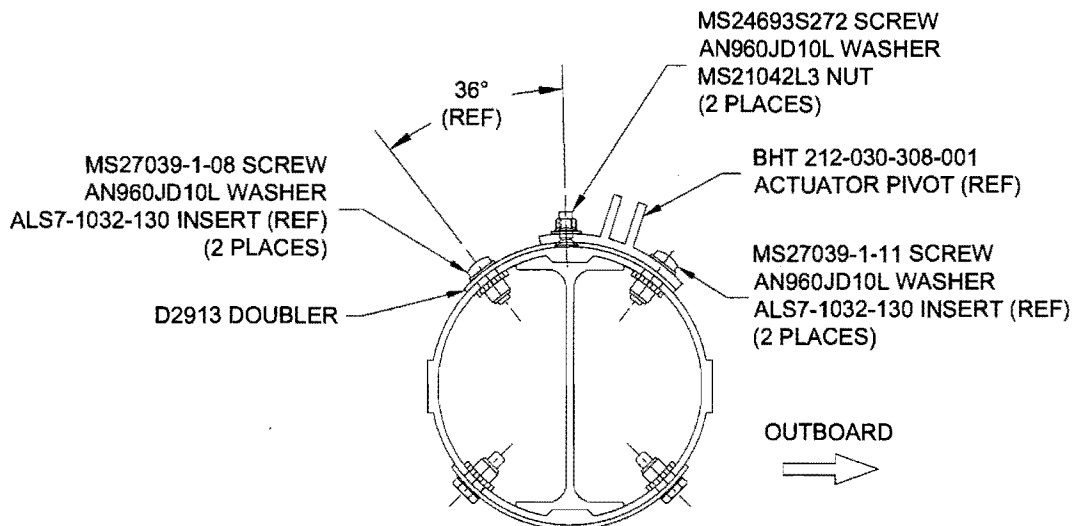


Section C-C – Typical DT8393-3 Pin Position
(See View A-A and B-B)



Section D-D – Bushing Installation
(See View A-A and B-B)

- 4.2.2 a) Install the D2913 Doubler onto the BHT 212-030-308-001 actuator pivot using MS24693 screws as shown in **Section E-E**.
- b) Install the assembly onto the skidtube using MS27039 screws as shown in **Section E-E**. Fasteners should be installed with Sikaflex-241/291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant on final installation.

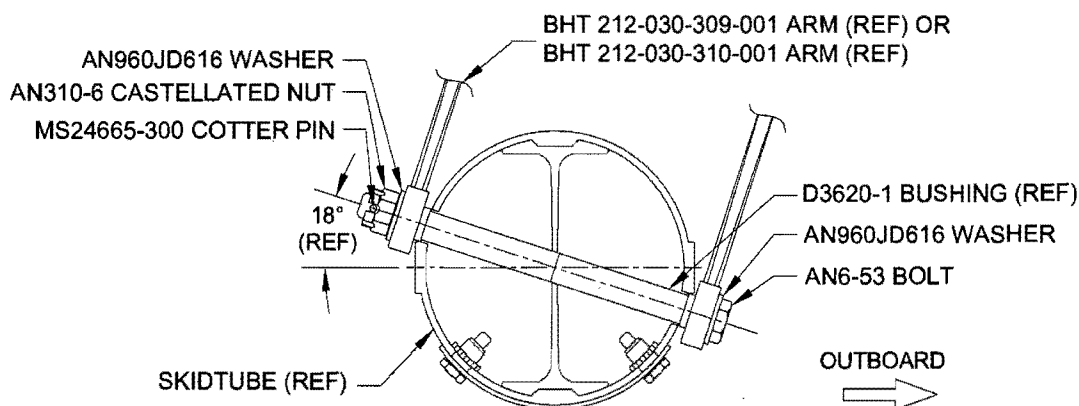


Section E-E – Doubler Installation

(See **Figure 4.1**; Approximately STA 111.9)

(LH Skidtube Installation Shown, RH Skidtube Installation Opposite)

- 4.2.3 Install the electric step arms to the skidtube as shown in **Section F-F**. Note that the step should be installed so that it is angled toward the outboard side of the skidtube as shown in **Section F-F**. Ensure all nuts are installed on the inboard side of the skidtube. It is acceptable to replace the AN6 bolts with longer or shorter AN6 bolts as required and/or install extra AN960JD616 washers under the nut to ensure proper installation of the cotter pin.

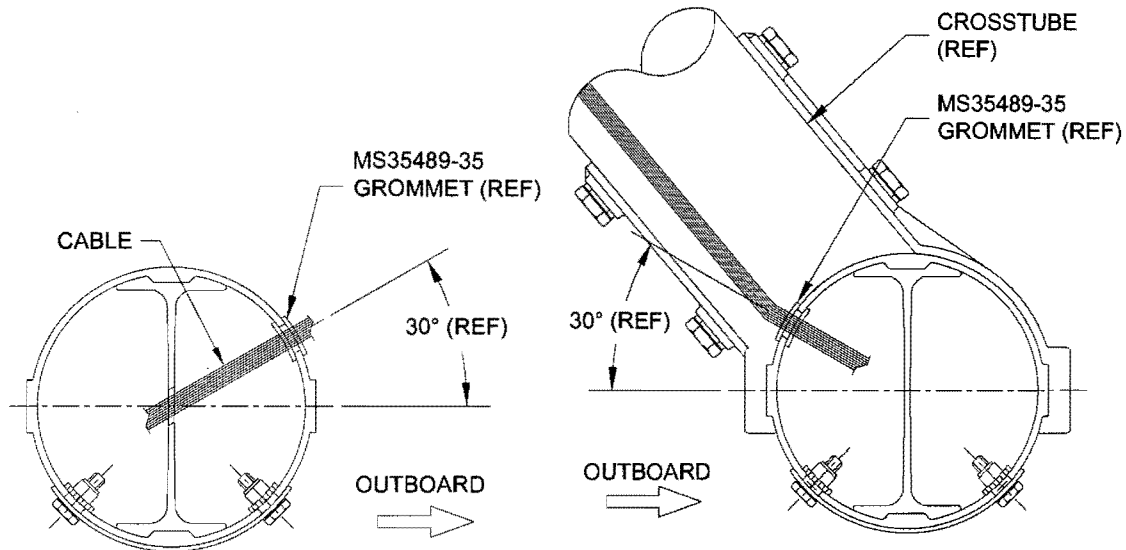


Section F-F – Electric Step Arm Installation

(See **Figure 4.1**; Approximately STA 100.4 and 130.0)

(LH Skidtube Installation Shown, RH Skidtube Installation Opposite)

- 4.2.4 Route the cabling from the step into the skidtube through the skidtube grommet at STA 114.8, through the I-beam web to the inboard side of the skidtube (refer to **Section G-G**), forward to the forward crosstube, out of the skidtube through the skidtube grommet at STA 71.5 and into the forward crosstube (refer to **Section H-H**).



Section G-G – Cable Routing Into Skidtube

(See **Figure 4.1**; Approximately STA 114.8)
(LH Skidtube Installation Shown, RH Skidtube
Installation Opposite)

Section H-H – Cable Routing Out of Skidtube

(See **Figure 4.1**; Approximately STA 71.5)
(LH Skidtube Installation Shown, RH Skidtube
Installation Opposite)

- 4.2.5 Complete the installation of the BHT Power Step Kit per the Aircraft Maintenance Manual.
- 4.2.6 Re-install the forward D2571/D2572 Saddles and D2594 Plugs onto the skidtube assembly, and re-install the skidtube assembly onto the aircraft per ICA-D205-634 (see **Figure 1.1** for the installed step).

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D412-673 REV. C

REF CANADIAN STC: SH96-88

REF FAA STC: SR00563NY

REF EASA STC: EASA.IM.R.S.01303

PURPOSE:

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD 4X D4398-1 BUSHINGS TO THE D412-673-011 ELECTRIC STEP ADAPTATION KIT, TO ENSURE COMPATABILITY WITH THE OEM ELECTRIC STEP.

PARTS LIST CHANGE:

QTY. -011	PART NUMBER	DESCRIPTION
X	D412-673-011	Electric Step Adaptation Kit

4	D4398-1	Bushing
---	---------	---------

— ADD

REFERENCE ONLY

PRELIMINARY ISSUE
ASS 11.05.04

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 11.05.03

CERT. NO.: SH96-88

ISSUE NO.: 3

A	NEW ISSUE	AJS	11.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9556	SHEET 1 OF 2
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.		BUSHING INSTALLATION	NTS
DATE	11.05.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

MODIFICATION PROCEDURE:

IT IS ACCEPTABLE TO PRESS OUT THE QTY 4 BUSHINGS LOCATED IN THE STEP ARMS (PART No. BHT 212-030-309-001 ARM OR BHT 212-030-310-001 ARM). REPLACE THE OEM BUSHINGS WITH QTY 4 D4398-1 BUSHINGS. ENSURE THAT THE SHOULDER OF THE BUSHING IS FACING OUT AS SHOWN IN FIGURE 1. AT THE INSTALLER'S DISCRETION, THE D4398-1 BUSHING MAY BE INSTALLED USING LOCTITE 601 (OR EQUIVALENT TO MIL-R-46082) APPLIED TO ALL MATING SURFACES.

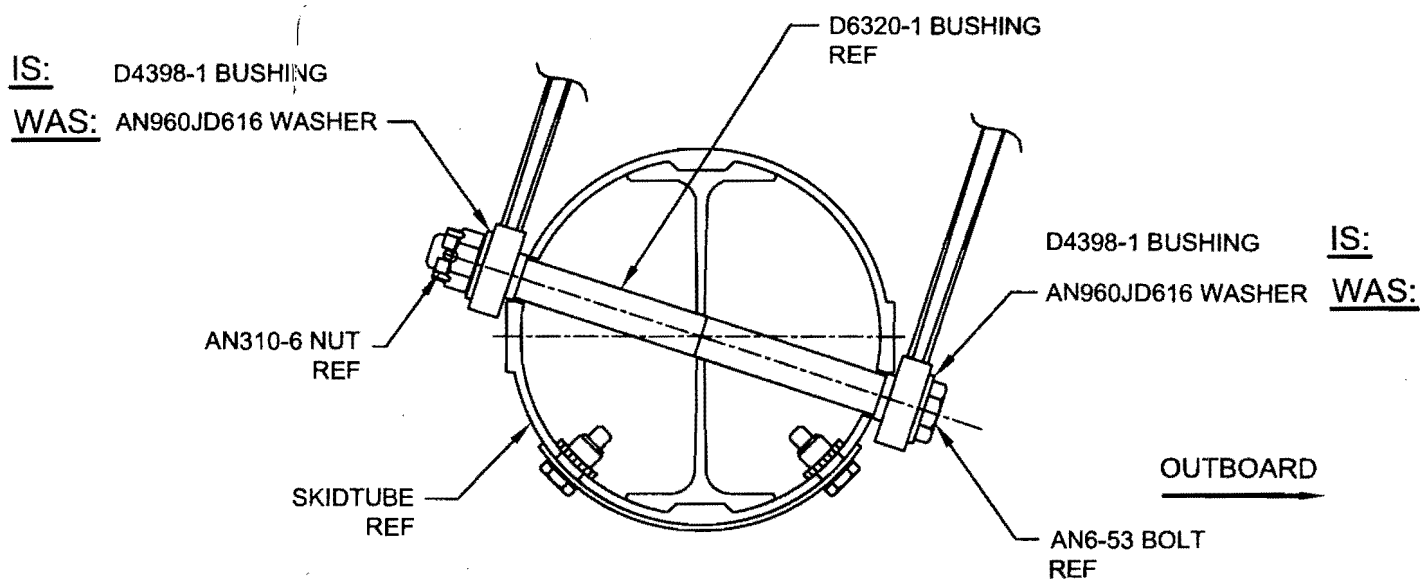


FIGURE 1: TYPICAL STEP INSTALLATION

REFERENCE ONLY

PRELIMINARY ISSUE
ASS 11.05.04

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 11.05.03

CERT. NO.: SH96-88

ISSUE NO.: 3

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9556	SHEET 2 OF 2
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.		BUSHING INSTALLATION	NTS
DATE	11.05.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date: 11.05.04	Job No.: ENG2108	ADR Yes/No: Y	ADR Date: 11.05.04	ECN #: 11- 563
Product No.: D205-673		Created By: AJS	Approved By: <i>[Signature]</i>	
Product Name: Electric Step Adaptation Kit		Checked By: <i>[Signature]</i>	General Manager Approval: N/A	

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	LL/MF		
Purchasing Coord.			
Production Engineering Coord.	JLM		

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.			
QC Coordinator			
Customer Technical Support	MB		
Marketing	SW		
Customer Order Processing			

Reason for Change: NEW PART

Documents Affected:
D4398 Rev. A

PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	AJS	TO BE RELEASED ON ECN 11-564	
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		11.05.04 <i>[Signature]</i>
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		11.05.04 <i>[Signature]</i>
13	Update Document Record (DR)	Y	KJ	Rev. 0	11.05.04 <i>[Signature]</i>
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update PPP's	N			
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	N			
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		11.05.04 <i>[Signature]</i>
24					

Description / Action:

Part may be shipped, parts will not be considered Airworthy until DSI 9556 is released on ECN-11-564. AJS 11.05.04

ECN Verified & Complete: _____ Date: _____

